

Work Order ID 69547

Page 1

Wednesday, May 11, 2011 3:16:40 PM

Item ID: D3651-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Outside Doubler

Start Date: 5/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

4-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3651 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

304.019

B 11-5-19

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-5-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11-5-19

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



⑥

SB 11/05/19

11/5/20

MF
11-05-19

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, May 11, 2011 3:16:46 PM

Page 1

Work Order ID: 69547



Parent Item: D3651-13



Parent Item Name: Outside Doubler

Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA

Purchased

No

100

sf

15.0000

0.68

4.294737



1311-5-19

304/316 0.018 SHEET

Location

Loc Qty

Loc Code

MAT020

15

109398

3

112885

12

112885

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	0954
Description: Outside Doubler		Part Number:	D3651-13
Inspection Dwg: D3651 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.132	✓		V 1B02	
0.260	+/-0.010	.260	✓		V	
2.471	+/-0.010	2.474	✓		V	
9.791	+/-0.010	9.794	✓		PROW502	
0.634	+/-0.010	.634	X		V	
2.564	+/-0.010	2.560	✓		V	
0.52	+/-0.030	.527	✓		V	
0.600	+/-0.010	.599	✓		V	
0.500	+/-0.010	.499	✓		V	
7.969	+/-0.010	7.961	✓		V	
2.348	+/-0.010	2.348	✓		V	
0.480	+/-0.010	.478	✓		V	
5.571	+/-0.010	5.561	✓		V	
0.696	+/-0.010	.694	✓		V	
7.049	+/-0.010	7.049	✓		V	
3.564	+/-0.010	3.560	✓		V	
0.694	+/-0.010	.695	✓		V	
1.779	+/-0.010	1.776	✓		V	
8.74	+/-0.030	8.736	✓		P	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-5-19	Date: 11/05/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	DD

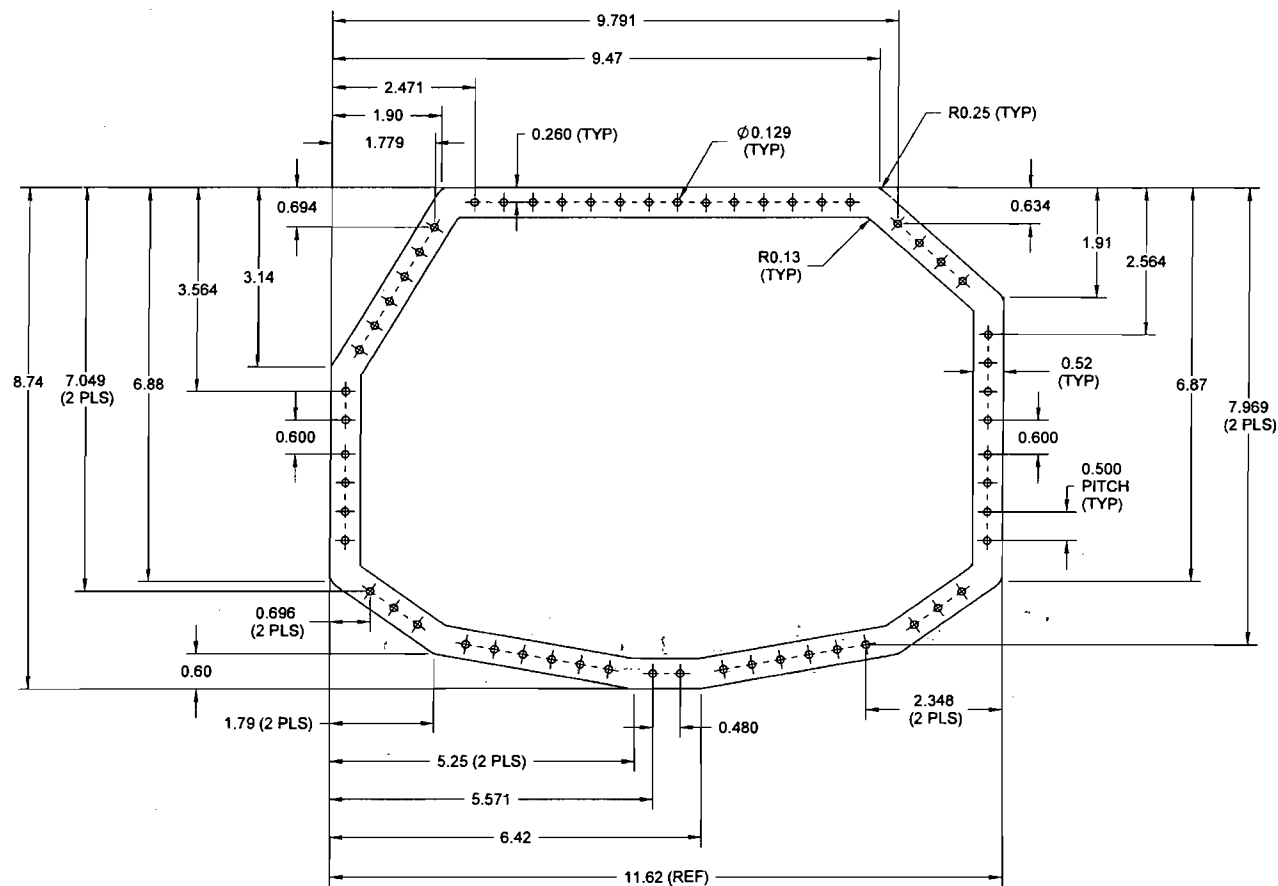
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NOTE: Date & initial all entries



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69547

11-05-1
08-03-27/11

D3651-13 OUTSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 LBS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	ME	DRAWING NO. D3651	REV. B
MFG. APPR.	ME		SHEET 8 OF 8
APPROVED	ME	TITLE AFT BASE ASSEMBLY	SCALE 12
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.07		

W/O:		WORK ORDER CHANGES					
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